Each

Monday, 02/02/2009 11:49:51 AM Çate: User: Julie Dawson **Process Sheet** : CU-DAR001 Dart Helicopters Services **Drawing Name** : TUBE Customer Job Number : 45385 **Estimate Number** : 11175 : D22825 **Part Number** P.O. Number : 02/02/2009 S.O. No. : **Drawing Number** D2282 REV E This Issue Prsht Rev. : NC Project Number : N/A : MACHINED PARTS ; E First Issue : // Type **Drawing Revision** : 44338 Material **Previous Run** : 28/02/2009 100 Um: **Due Date** Qty: Written By **Checked & Approved By** Removed from 9 Digit 05-12-02 JLM Comment : Est Rev:A Now on Doosan Lathe 08-06-05 JLM EstRev:B Verified By:EC Additional Product Job Number: Description: Seq. #: **Machine Or Operation:** M304R0750 304 SS Roundbar .750 1.0 0.1891 f(s)/Unit Total: Comment: Qty.: 18.9063 f(s) Material: AISI 304 Stainless Steel Ø0.750(M304R0.750) M110912 DOOSAN LATHE DOOSAN LATHE 2.0 Comment: DOOSAN LATHE 1-Turn as per Dwg D2282 and Folio FA189 2-Deburr INSPECT PARTS AS THEY COME OF MACHINE 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8

Comment: SECOND CHECK

PACKAGING 1

PACKAGING RESOURCE #1

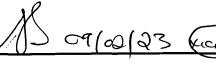
Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:_

· (L.





5.0

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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	<u></u>						<u> </u>					
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _						

NCR:			WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B	· · · · · · · · · · · · · · · · · · ·	Verification				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sign & Section C	Approval Chief Eng	Approval QC Inspecto		

Date:

Monday, 02/02/2009 11:49:51 AM

User:

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 45385

Part Number: D22825

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21



FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAI	NGE		By Date Qty Chief E				Approval QC Inspector
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Part No:		PAR #:	Fault Cate	jory:	_ NCR	: Yes	No DQ	A :	_ Date: _	
Resolution:			Disposition):	_ QA:	N/C Cld	sed:	-	Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	ANCE	(NCR)			
DATE	STEP	Description of NC	Corrective Action Section		on B		Verification		Approval	Approval
DATE	3121	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
								:		

DART AEROSPACE LTD	Work Order:	NS385
Description: Handle Tube	Part Number:	D2282-5
Inspection Dwg: D2282 Rev: E		Page 1 of 1

Inspection Dwg	j: D2282 Rev	:E				Pa	ge 1 of 1
	FIRS'	T ARTICLE II	NSPECT	ION CHE	ECKLIST		
	>	First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method o	1 1 An	nments
2.17	+/-0.030	2/65					
R0.063	+/-0.010						
0.063	+/-0.010	1.063					
0.125	+/-0.010	,125					
0.090 x 45°	+/-0.010	.094/50	•			-	
R0.350	+0.010/-0.000	1.350					
0.158	+/-0.010	.158					
Ø0.386	+0.005/-0.000	- 388					
Ø0.700	+/-0.010	,700					
							·
							<u> </u>
			-10	-			
Measured by:	A/	Audited by:	SP,		Prototype	e Approval:	N/A
Date:	01/02/21	Date:	09/02/	<i>a</i> 3		Date:	N/A
Rev Date	Change		_/_/			Revised by	Approved
A 03.11.11	New Issue	P/O D350-6				KJ/RF	
B 05.04.19 C 06.03.15	Dimensions & to			Ray F		KJ/JLM KJ/JLM	-
C 06.03.15			hei nwg i	VGA E		KUECIOD Z	11-12

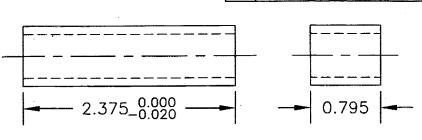
Rev	Date	Change	Revised by	Approved
Α	03.11.11	New Issue P/O D350-615-041	KJ/RF	
В	05.04.19	Dimensions & tolerances changed	KJ/JLM	
С	06.03.15	Dimensions & tolerances revised per Dwg Rev E	KJ/JLM , ,	
D	07.11.26	Ø0.700 dimension added	KJ/EC/DD	- X

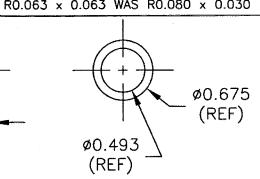
Dart Ae	rospace Ltd					•	•	
W/O:			WORK ORDER	CHANGES				
DATE	STEP	PRO	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				1				
Part No	:	PAR #:	Fault Category:	NCR: Ye	s No DQ	A:	Date: _	
	Resoluti	on:	Disposition:	QA: N/C	Closed:		Date: _	
NCR:		1	WORK ORDER NON-CON	IFORMANCE (NO	R)	***	- 	

NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCR)								
		Description of NC		Corrective Action Section B	Verification	Ammroval	Ammerical						
DATE	ATE STEP Description of NC Section A		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector					
					:								
		· ·						4.					

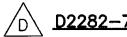


DESIGN DRAWN BY		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
CHECK	(ED:O	APPROVED	DRAWING NO. REV. E					
	w	1000	D2282 SHEET 1 OF 2					
DATE			TITLE SCALE					
05.0	6.07		HANDLE TUBES 1:1					
 Α		94.10.14	NEW ISSUE					
В		95.03.23	RE-DESIGN					
С		97.10.20	CORRECTED NUMBERING SCHEME					
D		05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750					
Ε		05.06.07	D2282-5 304 SS WAS 303 SS;					





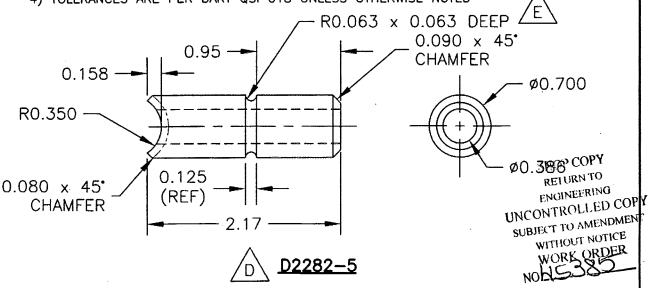
D2282-3



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

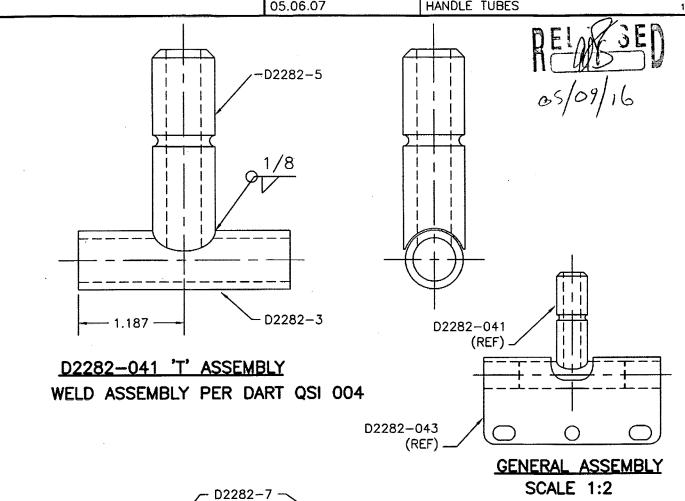
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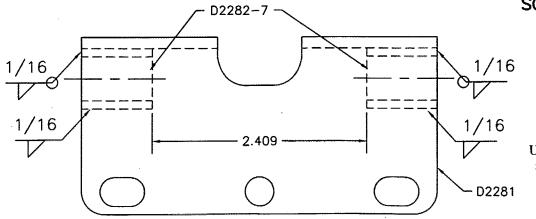
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Dart Ae	rospace	Lta							
W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	Re	esolution:	Dispositi	on:	QA: N/C CI	osed:		Date: _	
NCR:			NORK OR	DER NON-CONFORMA	NCE (NCF	R)		THE STATE OF	
		Description of NC		Corrective Action Section	n B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
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DESIGN BW	DRAWN BY	DART AEROS HAWKESBURY, ONT	
CHECKED	APPROVED	DRAWING NO.	REV. E
U'	lab	D2282	SHEET 2 OF 2
DATE		TITLE	SCALE
05.06.07		HANDLE TUBES	1:1





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D2282-043 SADDLE ASSEMBLY WELD ASSEMBLY PER DART QSI 004

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W/O:		WORK ORDER CHANGES								
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Part No		PAR #:								
	не	solution:						Date: _		
NCR:	1		WORK OR	DER NON-CONFORM	•	CR)		·	7	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	ction B Sig		rification Section C	Approval Chief Eng	Approval QC Inspector	
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